

13 Recd PCT/PTO 14 SEP 1992

- 1 -

~~SPECIFICATION~~

A PRESSURE WAVEFORM SETTING METHOD FOR INJECTION

PRESSURE CONTROL AND AN INJECTION MOLDING MACHINE

~~Background of the Invention~~
~~Technical Field~~

1. Field of the Invention

5 The present invention relates to an injection
molding machine capable of providing feedback control
of an injection pressure for making it equal to a
target injection pressure in the injection and dwell
stages, more particularly, to a method for setting
10 waveform of an injection pressure to be used in setting
a target value and an injection molding machine for
carrying out this method.

2. Description of the Related Art
~~Background Art~~

15 Generally, according to a conventional injection
molding machine, the injection speed is set in
accordance with the advanced position of a screw, and
the advancing speed of the screw is controlled to be
made equal to the set injection speed, in an injection
stage. In a dwell stage, the machine is controlled so
20 that a set dwell pressure is applied to a resin.

In actual molding operation, however, the
propriety of the injection pressure influences the
conformity of molded articles much more greatly than
that of the injection speed. It is desirable,
25 therefore, that the injection pressure should be
feedback-controlled during the injection and dwell
stages. The inventor hereof proposed a control system
in which a pressure sensor is mounted on a screw shaft,
and the dwell pressure is feedback-controlled by
30 detecting a pressure of the resin acting on the screw
shaft. This is disclosed in Published Unexamined
Japanese Patent Application No. 62-218118. However,